

Work Order ID 73768-1

Thursday, September 15, 2011 8:55:17 AM

Page 1

Item ID: D6101-001

Revision ID:

Item Name: Saddle Billet

Start Date: 9/15/2011 Start Qty: 40.00

Required Date: 9/30/2011 Req'd Qty: 40.00

Reference:

Approvals: Process Plan:

QC:

Date:

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Setup Start

Stop

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D6101

Rev B

100



Purchasing

Purchasing

PURCHASING

0.00

0.00

Memo

Issue P/O: 14899

a) Description: Aluminum billet

b) 6.00" x 6.250" x 2.00" thick

c) Tolerance on length are +0.030"/-0.000" ~~+/-0.008"~~

d) Grain direction along 6.00" length

e) Material: 7075-T7351 (QQ-A-250/12)

f) Material certification required

110



Packaging

Packaging

Receive & Inspect for Damage & Mat'l Certs

0.00

Memo

Ensure material certification is attached

0.00

11-09-15
40

11/9/11 (20)

Work Order ID 73768

Thursday, September 15, 2011 8:55:17 AM

Item ID: D6101-001

Revision ID:

Item Name: Saddle Billet

Start Date: 9/15/2011 Start Qty: 40.00

Required Date: 9/30/2011 Req'd Qty: 40.00

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC6- Inspect dimensions to drawing

0.00



QC

Quality Control

Memo

Ensure Material certification comply to Dwg D

0.00

SL 11-09-19

20

130

Identify as per dwg & Stock Location: MAT 40

0.00



Packaging

Packaging

Memo

0.00

SL 11-09-19

140

QC21- Final Inspection - Work Order Release

0.00



QC

Quality Control

Memo

0.00

11/9/19
MK 11-09-19

Picklist Print

Thursday, September 15, 2011 8:55:15 AM

Work Order ID: 73768

Parent Item: D6101-001

Parent Item Name: Saddle Billet



Start Date: 9/15/2011

Start Qty: 40.00

Required Date: 9/30/2011

Required Qty: 40.00

Comments: IPP B: 01.05.04 New Issue EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D6101-001P

Purchased

No

110

Each

0.0000

1

40

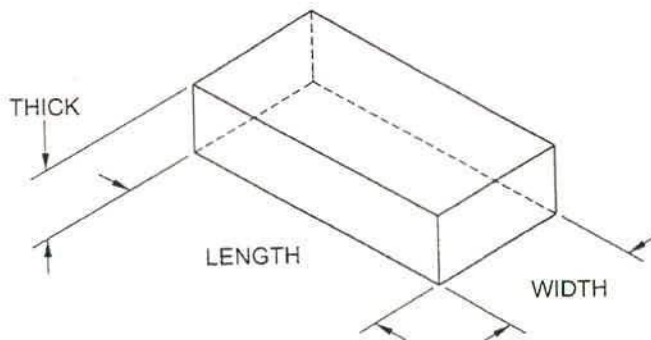


7075-T7351 2X6X6.25



Rec'd 9/19/11 (20)

SPECIFICATION CONTROL DRAWING



PURCHASE MATERIAL ACCORDING TO THE FOLLOWING TABLE. SPECIFY ALLOY, LENGTH x WIDTH x THICK (+0.030/-0.000), AND GRAIN DIRECTION AS SHOWN.

TOLERANCES ON ALL DIMENSIONS ARE +0.030/-0.000.

ALL DIMENSIONS ARE IN INCHES.

△ ACCEPTABLE SPECIFICATIONS FOR 7075-T7351 ALUMINUM ARE AMS-QQ-A-250/12, QQ-A-250/12, OR ASTM B209

Part No.	Alloy	Length	Width	Thick	Grain Direction
D6101-001	7075-T7351 (QQ-A-250/12)	6.000	6.250	2.000	Along 6.000 Length
D6101-003	7075-T7351 (QQ-A-250/12)	7.875	6.250	2.000	Along 7.875 Length
D6101-005	7075-T7351 (QQ-A-250/12)	5.000	8.250	2.500	Along 5.000 Length
D6101-007	7075-T7351 (QQ-A-250/12)	7.750	8.250	2.500	Along 7.750 Length
D6101-009	7075-T7351 (QQ-A-250/12)	8.700	8.250	2.500	Along 8.700 Length
D6101-011	7075-T7351 (QQ-A-250/12)	9.700	8.250	2.500	Along 9.700 Length
D6101-013	7075-T7351 (QQ-A-250/12)	10.100	8.250	2.500	Along 10.10 Length
D6101-015	7075-T7351 (QQ-A-250/12)	9.450	6.250	2.500	Along 9.450 Length
D6101-017	7075-T7351 (QQ-A-250/12)	6.350	6.250	2.250	Along 6.350 Length

△ B

w/ 73768

RELEASED
09/07/15/WB

B	ADDED D6101-015/-017, ADD ASTM B209	RF	09.04.23
A	NEW ISSUE	CP	01.03.30
REV.	DESCRIPTION	BY	DATE
DESIGN	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D6101	SHEET 1 OF 1
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	SADDLE BILLET, 7075	NTS
DATE	09.04.23	COPYRIGHT © 2001 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

Shipment No:982684

m: Castle & Co. (Canada) 3615 3615 KIRK AVENUE 3615 LAUREL, QUEBEC		Sold To: DART AEROSPACE LTD 1270 ABERDEEN HAWKESBURY, ON K6A 1K7 CA		Ship To: DART AEROSPACE LTD 1270 ABERDEEN HAWKESBURY, ON K6A 1K7 CAN		Deliver To: DART AEROSPACE LTD 1270 ABERDEEN HAWKESBURY, ON K6A 1K7 CA	
Exported 011	F.O.B. ORIGIN	Freight Terms Prepaid		Carrier MANITOULIN		BOL No 982684-2	

Details	Final Destination Branch - MON
----------------	---------------------------------------

Line No	Item No	Description
1	752237.MO	2.0000.PL.7075.T7351.ALUMINUM.US1.48.5000.144.5000 CUT 2SIDED TO 6.25 IN (+ .0310/- .0000 IN (GRAIN TO RUN ALONG 6")) X 6 IN (+ .0310/- .0000 IN (GRAIN TO RUN ALONG 6")) - ALUMINUM PLATE SAW SPECIFICATIONS: QQ-A-250/12

Order No EASE 14899	Part Number YOUR ITEM NUMBER: D6101-001	Ordered Qty 20.00 PCS	Invoice Qty 20 PCS
ATTN MONTREAL: HOLD FOR RELEASE			

lo.	Mill	Heat Number	Mech Id	PCS	Width (IN)	Length (IN)	Shipped Qty(LBS)
		589281		20			154.83

Technologies are subject to US Export Administration & US State Dept. Regulations and, if intended for export, were/are exported thereunder. Diversion contrary to US Law is Prohibited.

The material covered by this certification conforms in accordance with the above specifications and has been found to meet the applicable requirements for the material, including any specifications forming a part of the description. The material is subject to examination. All claims for defective material are waived unless made in writing to A.M. Castle & Co. within 60 days of the shipment. Material cut to the correct size, or material cut by the customer cannot be returned.

Authorized Castle Metals Representative:	Date:	Name:
--	-------	-------

CERTIFIED INSPECTION REPORT

Alcoa Inc.

PITTSBURGH, PA DAVENPORT WORKS

Ship From: RIVERDALE, IA.

We hereby certify that the material covered by this certificate has been inspected with, and has been found to meet, the applicable requirements described therein, including any specifications forming a part of the description and that samples representative of the material met the composition limits and had the mechanical properties shown on the face of this sheet.

Per

Malcolm Murphy

Malcolm Murphy
Director of Manufacturing Davenport Works

Kennon P. Young

Kennon P. Young
Quality Assurance Manager

1061390	0				
Ship Date	B.L. No.	Invoice No.	Alcoa No.	Item	Page 1
2009-10-26	4323476	00000	1000138855-3		DS-38855-3
P.O. No./Govt Contract No.	Customer	Alcoa Item			
14685 Ln# 3	CASTLE METALS	G041003428R14			

Ship To: A M CASTLE & COMPANY
3050 SOUTH HYDRAULIC
WICHITA 67216 KS

Item Description
2.0 IN TH (-.055 -.055) X 48.5 IN W (+.3125 -
0.000) X 144.5 IN LN (+.5 -.0) CAT D 164164 (N) A/T 7075-
T7351 RECTANGLE MILL FINISH, USI 3MM DEAD ZONE REQ'D BOTH SIDES,
SAWED IAC 5857, EXC_MRK A97075-60 REV 25 AMS-QQ-A-250/12 IS 2007 AMS-
STD-2154 EXC_MRK AMS4078 REV 3 EXC_MRK ASTM209
REV 07 ASTM2594 REV 06 BSG7055 REV A
EXC_MRK MMS159 REV N FS21211 REV K ((MARKED))
KRAFT PAPER INTERLEAVED
MAX GROSS SKID WGT: 4500 LB QUAN TOL +/-
40 % USI CL A 3 MM CQR 0107687 REV 32 CUST REQ 09-10-
25 *** W/E 09-10-31 ***

Num	Package Ticket	Lot	Weight	Quantity	UCM	Inspector Clock Numbers
1	759932	589281	1423	1	PC	47091
2	759995	589281	1433	1	PC	47091
			2356	2		

Notes for CQR: 0107687.32

PRODUCT PRODUCED TO THE REQUIREMENTS OF MIL-STD-2154 ALSO MEET THE REQUIREMENTS OF AMS-STD-2154 PRODUCT PRODUCED TO THE
REQUIREMENTS OF AMS-STD-2154 ALSO MEET THE REQUIREMENTS OF MIL-STD-2154.
THIS MATERIAL HAS BEEN ULTRASONICALLY INSPECTED FULLY IMMERSON - TYPE I.
THIS MATERIAL HAS BEEN ULTRASONICALLY INSPECTED FULLY IMMERSON - TYPE I.
PRODUCT PRODUCED AND MARKED TO THE REQUIREMENTS OF AMS-QQ-A-250/12 ALSO MEETS THE REQUIREMENTS OF QQ-A-250/12F. PRODUCT
PRODUCED AND MARKED TO THE REQUIREMENTS OF QQ-A-250/12 F ALSO MEETS THE REQUIREMENTS OF AMS-QQ-A-250/12.
Exception to Spec A97075-60 ; Revsn: 25 Issue: Letter dated 2008-12-11 from TUCKER, BONNIE to PLATTER, B.

CQR: 0107687 32 -Specification Limits

Temp	Dir	UTS	TYS	EL4D
		KSI	KSI	PCT
T7351	Long Transv.	Max	68.9	
		Min	69.0	5
T7351	Elec. Cond. (EC) % MIN	38.0	PCT	

Chemical Composition		SI	FE	CU	MN	MG	CR	ZN	TI	Other	Other	Total Aluminum
										Each	Total	
Alloy 7075	Max	0.40	0.50	2.0	0.30	2.9	0.28	6.1	0.30	0.05	0.15	
	Min			1.2		2.1	0.18	5.1				REMAIN

CERTIFIED INSPECTION REPORT

Alcoa Inc.

PITTSBURGH, PA DAVENPORT WORKS

Ship From: RIVERDALE, IA.

We hereby certify that the material covered by this certificate has been inspected with, and has been found to meet, the applicable requirements described therein, including any specifications forming a part of the description and that samples representative of the material met the composition limits and had the mechanical properties shown on the face of this sheet.

Per:

Malcolm Murphy

Malcolm Murphy
Director of Manufacturing Davenport Works

Kenton P. Young

Kenton P. Young
Quality Assurance Manager

1061390	0			
Ship Date	B.L. No.	Invoice No.	Alcoa No.	Item
2009-10-26	4323476	00000	1000138855-3	DS-38855-3
P.O. No./Govt Contract No.	Customer	Alcoa Item		
14685 Ln#: 3	CASTLE METALS	G041003428R14		

CQR: 0107687.32 -Specification Limits (cont.)

Lot: 569281 - Mechanical, Physical, Metallography, Quantometer Results

Temp	Dir	No->	UTS	TYS	EL4D
T7351	Long Transv.	3	KSI	KSI	PCT
			72	61.3	10.8
			71.9	61.3	11.3
			71.6	61	11

T7351 Elect Cond %IACS 40.8 40.9 41.0 PCT

Cast Number	Chemical - CES	SI	FE	CU	MN	MG	CR	ZN	TT
H4588024	Actuals	0.06	0.30	1.6	0.02	2.4	0.19	5.7	0.02

This material was melted in the United States or a Qualifying Country [REF DFARS 225.972.1(a)], it was manufactured in the United States